DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-019673
Date Inspected: 13-Jan-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Mr.Zhu Zhong Hai.			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☐ No	☑ N/A

Bridge No: 34-0006
Component: Tower and Orthotropic Box Girder (OBG)

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

NDT
BAY 11:
This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as OBG Bike Path. The weld designations reviewed are as follows.
BK008A3-002-017, 042, 060
BK008A4-002-008, 035, 023, 075
BK008A6-002-024
BK008A8-002-024

NDT Notification No-08161

BAY 10
This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-

6027 (UT) report for this date. The member is identified as OBG Bike Path. The weld designations reviewed are as follows.

BK004ASD1-032-022, 023, 024, 027
BK007A5-001-112, 118, 121, 122, 128, 131
NDT Notification No-08155

This QA Inspector observed the following work in progress:

BAY 10:
SMAW process:
This QA Inspector observed ZPMC qualified welding personnel identified as 057220, Perform Shielded Metal Arc Welding (SMAW) on OBG Traveler rail. Joint identified as 29TR1-003, 005. ZPMC QC Identified as Jiang Xiang Bo. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-B-U2.

This QA Inspector observed ZPMC qualified welding personnel identified as 040582, Perform Shielded Metal Arc Welding (SMAW) on OBG Traveler rail. Joint identified as 28TR1-014, 015. ZPMC QC Identified as Jiang Xiang Bo. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-B-U2.

This QA Inspector observed ZPMC qualified welding personnel identified as 056364, 056200, Perform Shielded Metal Arc Welding (SMAW) on South Tower lift 6, B/C Corner joint from Outside. Joint identified as SSD1-TL6-1C/D-014. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2314-Tc-P5.

FCAW Process:
This QA Inspector observed ZPMC qualified welding personnel identified as 053869, Perform Flux Core Arc Welding (FCAW) on South Tower lift 6, A/B Corner joint from inside. Joint identified as SSD1-TL6-1C/D-024. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 052075, Perform Flux Core Arc Welding (FCAW) on South Tower lift 6, C/D Corner joint from outside. Joint identified as SSD1-TL6-1C/D-016. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-ESAB.

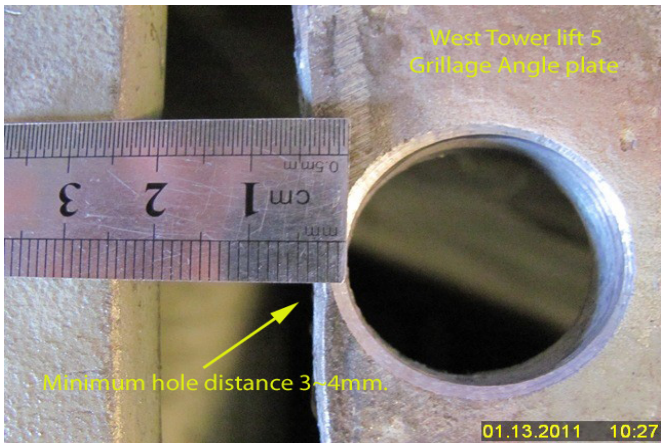
BAY 11: SMAW process:
This QA Inspector observed ZPMC qualified welding personnel identified as 040614, Perform Shielded Metal Arc Welding (SMAW) on East Tower lift 6, C/D Corner joint. Joint identified as ESD1-TL6-2C/D-011. ZPMC QC Identified as Xu Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2312-Tc-P5.

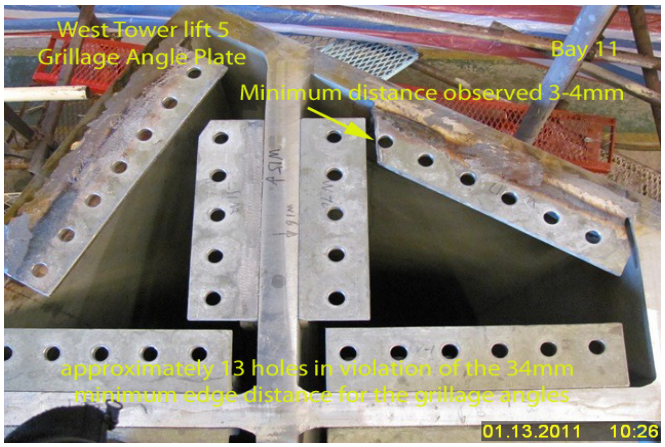
This QA Inspector observed ZPMC qualified welding personnel identified as 040655, Perform Shielded Metal Arc

Welding (SMAW) on East Tower lift 6, D/E Corner joint. Joint identified as ESD1-TL6-2C/D-006. ZPMC QC Identified as Xu Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2312-Tc-P5.

BAY 11:
This QA Inspector observed in Bay 11on Tower lift 5 West, North, East and South approximately 13 holes in violation of the 34mm minimum edge distance for the grillage angles minimum distance observed 3~4mm. For more information see below attached picture.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.





Summary of Conversations:
Only general conversation was held between QA and QC concerning this project.
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho: 150002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer